

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	R44 WEARPLATE
Job Number	36487		Part Number	D35651
Estimate Number	12651		Drawing Number	D3565 UNDERR REVIEW
P.O. Number	:		Project Number	N/A
This Issue	12/20/2007 S.O. No. :		Drawing Revision	UR
Prsht Rev.	NC		Material	:
First Issue	11 Type : SMALL /MED FAB		Due Date	1/20/2008
Previous Run	36445		Qty:	40
Written By	HJ 07.12.21		Um:	Each
Checked & Approved By				
Comment	Est Rev A New Issue 07-01-16 JLM est rev B revB dwg 07.04.18 ec			

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet 5.9556
		Comment: Qty.: 0.1418 sf(s)/Unit Total: 5.6700 sf(s) 304/316 .060 Sheet Batch: 106653 B 08-1-2
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3565 Dwg Rev: C B 08-1-2 Prog Rev: C
		2-Deburr if necessary B 08-1-2
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE B 08-1-2
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK Comment: SECOND CHECK counter X42
5.0	D30093	CUP
		Comment: Qty.: 3.0000 Each(s)/Unit Total: 120.0000 Each(s) CUP: 36594 B36431 X18 B36594X6 FC 08/02/12
		B



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Drawing Name: R44 WEARPLATE

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Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3565

FC 08/02/12

2-Weld hard facing as per Dwg D3565

FC 08/02/13

A/R 2059B Hard Coat rod

Batch:

M106839 - FC 08/02/12 (8)

7.0 QC9

VISUAL WELDING INSPECTION
ENGINEERING APPROVAL

Comment: VISUAL WELDING INSPECTION

QC9 => PD 08.02.12 (8)

08.02.12 (8)

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 08/02/13

(8X)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JSL

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.02.13

(X8)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 498

AS 08/02/13

(X8)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

Doe/02/14

Job Completion



min 2008/2/14 (8)

V

POSITIVE RECALL

EFFECTIVE 02.02.14 AUTH

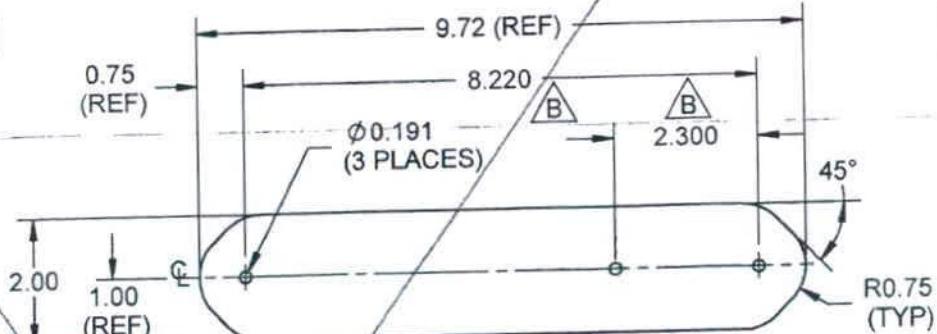
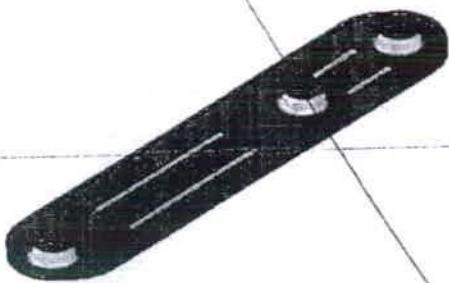
RELEASED 08.02.14 DATE

H

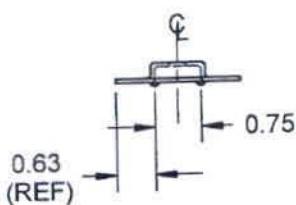


DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JB</i>	APPROVED <i>MM</i>	DRAWING NO. D3565
DATE 07.03.12		TITLE R44 WEARPLATE
REV A	DATE 07.01.09	SCALE 1:3
REV B	DATE 07.03.12	DESCRIPTION NEW ISSUE 8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING

**D3565-1F FLAT PATTERN**

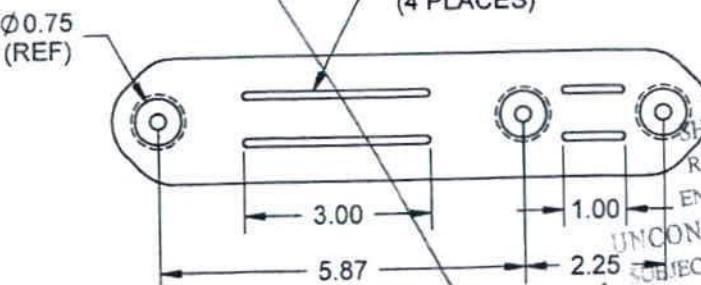
PUNCH Ø 0.191 HOLES WITH
Ø 0.75 x 0.25 DEEP PUNCH TOOL
(3 PLACES)



OPEN HOLES TO Ø 0.257 AFTER
PUNCHING OPERATION (IF NECESSARY)



2059B HARDCOAT WELDS
0.063 TO 0.125 THICK
(4 PLACES)

**RELEASED**

07.03.23

UNDER REVIEW

07.12.10

RE-DESIGN

D3565-1 R44 WEARPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO.

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) (REF DART SPEC M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3565-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WELD PER QSI 004
- 8) PART IS SYMMETRIC ABOUT \varnothing

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DART AEROSPACE LTD	Work Order:	36487
Description: R44 WEARPLATE	Part Number:	D3S6S-1
Inspection Dwg:D3S6S-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	R	Audited by:	C	Prototype Approval:	JP
Date:	08-1-2	Date:	Jeff	Date:	08-31-02
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	

